

Date: Wednesday, 6/27/2007 8:43:07 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JOGGLE BRACKET		
Job Number	: 33145		Part Number	: D35801		
Estimate Number	: 12912		Drawing Number	: D3580 PREL.A07.06.25		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/27/2007	S.O. No. : N/A	Drawing Revision	: UNDER REVIEW		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 6/26/2007	Type : SMALL /MED FAB	Due Date	: 6/29/2007	Qty:	40
Previous Run	: N/A		Um:	Each		
Written By	: <u>ER</u>					
Checked & Approved By	:					
Comment	: Est Rev :A New Issue 07.06.25 EC					

Additional Product	POSITIVE RECALL		
	EFFECTIVE	07-06-27	AUTH <u>ER</u>
	RELEASED	<u>ER</u>	DATE 07-06-27
POSITIVE RECALL			

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	M304S18GA	304/316 .050 Sheet
		

Comment: Qty.: 0.0105 sf(s)/Unit Total : 0.4200 sf(s)

304/316 SS sheet 0.050" thick

Batch: M100947 HB 07-06-27

2.0	WATER JET	FLOW WATER JET
		

Comment: FLOW WATER JET

1-Cut as per Dwg D3580

Dwg Rev: A

Prog Rev: A

2.0	Deburr if necessary	HB 07-06-27
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	<u>HB 07-06-27</u>	

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
		
	<u>Counted</u>	
	<u>HB 07-06-28</u>	

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	<u>HB 07-07-06</u>	
	<u>34</u>	
	<u>8/8 07/07/06</u>	

Date: Monday, 09/07/2007 7:11:30 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JOGGLE BRACKET

Job Number: 33145

Part Number: D35801

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP

Set up



Comment: INSPECT WORK TO CURRENT STEP

6.1

POWDER COATING

POWDER COATING



Comment: POWDER COATING

6.2

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP 07/07/08 (34)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/07/12 (34)

Job Completion



10/07/12

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JOGGLE BRACKET

Job Number: 33145

Part Number: D35801

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**

LE 07.04.06



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



POSITIVE
RECALL

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

6.1

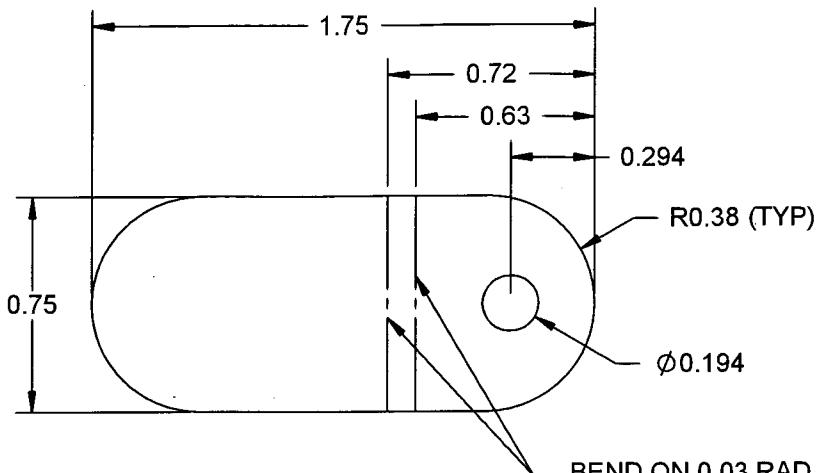
Powder coat grey sandbar (4.3.5.6) per
Q51 005

6.2

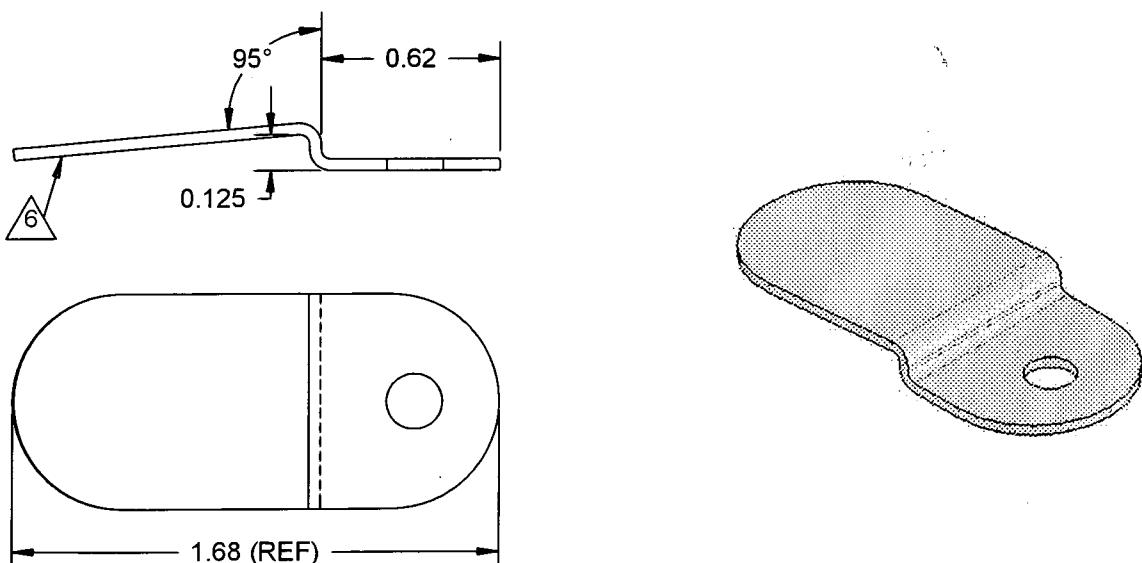
QC3

PRELIMINARY ISSUE
LE 07.06.28

DESIGN LE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED LE	APPROVED	DRAWING NO. D3580	REV. A	SHEET 1 OF 1
DATE 07.05.15		TITLE JOGGLE BRACKET	SCALE 3:2	
REV A	DATE 07.05.15	DESCRIPTION NEW ISSUE		



D3580-1F FLAT PATTERN



D3580-1 JOGGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

DART AEROSPACE LTD	Work Order:	33145
Description: TOGGLE BRACKET	Part Number:	03580-1
Inspection Dwg: 3590 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BS / ml	Audited by:	SV	Prototype Approval:	✓/A
Date:	27-06-07 07-06-07	Date:	07/06/08	Date:	
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/06	S	6 piece were sew out of Tolerance	OS 104L	Scrap - destroy	SDS 07/07/06	07-07-06	07/07/06	07/07/06

NOTE: Date & initial all entries